

WHAT IS CLAIMED IS

1. A corrugating machine for the manufacture of sheets of corrugated board (62, 67), comprising
 - 5 - at least two unroll stands (2, 9, 21) for unwinding webs of material (3, 8, 22) from reels of material;
 - at least one fluting unit (10) for the manufacture of at least one corrugated medium (8) from one of the webs of material;
 - at least one processing equipment (1, 36, 37) for uniting the corrugated
10 medium (8) and at least another web of material (3, 22) to form a web of corrugated board (41);
 - a cutting station (48, 54) for cutting the sheets of corrugated board (62, 67) from the web of corrugated board (41);
 - wherein at least one digital printing system (27; 69) for printing at least
15 one of the webs (3, 22; 41; 3; 22) is disposed between the unroll stands (2, 9, 21) and the cutting station (48, 54).
2. A corrugating machine according to claim 1, wherein the printing system (27) is disposed upstream of the processing equipment (1, 36, 37) seen in a
20 direction of production.
3. A corrugating machine according to claim 1, wherein at least one heating device (16, 36) for heating the corrugated medium (8) and the at least one further web of material (3, 22) is provided upstream of the at least one
25 processing equipment (1, 36, 37), the printing unit (4, 26) being disposed upstream of the heating device (16, 36).

4. A corrugating machine according to claim 1, wherein at least one printing system (69) is disposed downstream of the processing equipment (1, 36, 37).
- 5 5. A corrugating machine according to claim 1, wherein the printing system (27; 69) is embodied for unilateral printing of at least one of the webs (3, 22; 41).
6. A corrugating machine according to claim 1, wherein the printing system
10 (27; 69) is embodied for bilateral printing of at least one of the webs (41).
7. A corrugating machine according to claim 1, wherein at least one measuring device (19, 44; 19, 75, 76; 44; 75, 76) is provided, which is in signaling connection with the printing system (27) and which is embodied for
15 registering marks (17, 18) on at least one of the webs of material (3) and for determining, from the registered signal, a modification of the dimensions between the web (3) when at the printing system (27) and the web (3) when upstream of the cross-cutting unit (48, 54) for sheets of corrugated board (62, 67) to be cut at least true to the dimensioning of the web (3) in
20 the longitudinal direction thereof.
8. A corrugating machine according to claim 7, wherein two measuring devices (19, 44) are provided for registering a modification of the web dimensions, one of the measuring devices (19) being located at the printing
25 system (27) and the other measuring device (44) in the vicinity upstream of the cutting station (48, 54).
9. A method for the manufacture of sheets of corrugated board on a corrugating machine, comprising the following steps:

- providing a corrugating machine which comprises at least two unroll stands for unwinding continuous webs of material as well as at least one processing equipment for producing at least one web of corrugated board from the webs of material;
- 5 - digitally printing at least one web of material on the corrugating machine; and
- cutting the sheets of corrugated board from the digitally printed web of corrugated board in accordance with the shape and size of digitally im-
- 10 printed patterns.

10. A method according to claim 9, wherein two webs of material are digitally printed prior to being united to form a web of corrugated board.

11. A method according to claim 9, wherein at least one web of material is
15 printed digitally after it has been joined to at least a second web of material, forming a web of corrugated board.